

154227

Tuesday, December 06, 2016 2:50:55 PM

N900040100

Stop ***NS2***

g

g

Required Date: 12/12/2016 **Req'd Qty:** 8.00

Run Start *NR1*

Date: DEC 07 2016

Date:

Stop *NR2*

Date: _____

Date:

**Insp.
Stamp**

D

0.02

100

Waterjet

FLOW CNC Waterjet

Memo

0.19

1-Cut as per Dwg D3805

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

0.00

1 10

QC

Quality Control

Memo

0.01

⑧ _____ a 16/12/08

(8) _____ on 16/12/08

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Page 2

Item ID: D3805-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 12/7/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/12/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.03

Quality Control

8

DAS
38
9-89

DEC 12 2016

130

QC8- Inspect parts - second check

0.02

130

Brake NC

Memo

0.05

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

DAS
30
9-89

8

DEC 12 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.03

Quality Control

8

DAS
38
9-89

DEC 12 2016

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Item ID: D3805-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 12/7/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/12/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>WA01</u>	0.00				<u>8</u>	<u>2</u>	<u>161212</u>	
150									
Packaging	Memo	0.01							
Packaging	LOCATION WA001								
160	QC21- Final Inspection - Work Order Release	0.00							<u>16/12/13</u> <u>20</u>
160									
QC	Memo	0.13							
Quality Control									

16-12-13

Picklist Print

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Work Order ID: 154227

154227

Parent Item: D3805-5

D3805-5

Parent Item Name: Plate

Start Date: 12/7/2016

Required Date: 12/12/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	126.6930	1.587	13.36421			

M304S18GA

304/316 .050 Sheet

17.6

on 12/12/08

Location

Loc Qty

Loc Code

MAT020

119.593

M133328

55.224

M133587

0.7

M134824

4.375

M135779

20.84

M136036

38.454

MAT20

7.1

M134580

7.1

2.3

12.3

DQA: _____ Date: _____

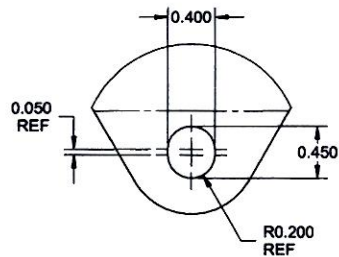


WORK ORDER NON-CONFORMANCE / UPDATE

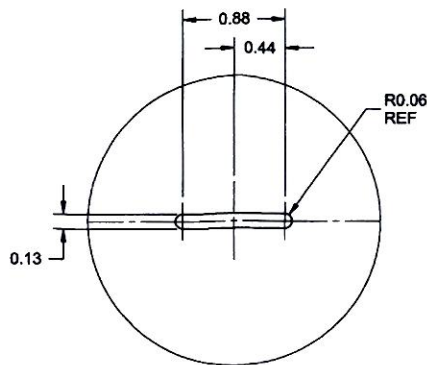
QA Closed: _____ Date: _____

Work Order update only ☐

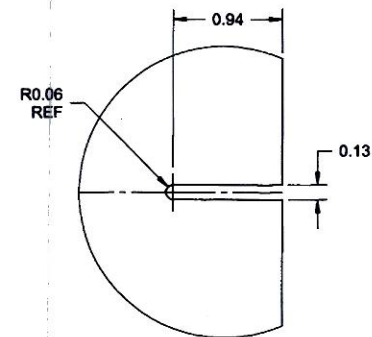
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



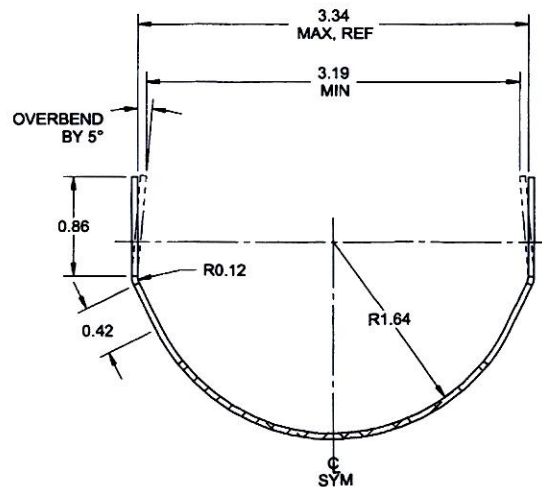
DETAIL B
SCALE 4X
B7-5
B7-6
B5-7
B5-8



DETAIL C
SCALE 4X
C5-5
C5-6
C4-7
C4-8



DETAIL D
SCALE 4X
C1-5
C1-6
C1-7
C1-8



SECTION A-A
SCALE 4X
D3-5
D3-6
D3-7
D3-8

RELEASED
2016-03-31

APPROVED

DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3805	SHEET 9 OF 9
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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